

Work Order ID 69052

Wednesday, April 27, 2011 11:28:00 AM

Page 1

Item ID: D3955-23

Accept

Setup Start

Revision ID:

Stop

Item Name: Template

Start Date: 4/27/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3955	A								

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

6061.040

1-Cut as per Dwg D3955

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-5-5

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69052

Wednesday, April 27, 2011 11:28:00 AM



Page 2

Item ID: D3955-23

Accept



Setup Start



Revision ID:

Stop



Item Name: Template

Start Date: 4/27/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/11/05/105

(44)

Quality Control

N/A

130

Identify as per dwg & Stock Location: 98

0.00



Packaging

Memo

0.00

11/5/6

408

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/5/97

Quality Control

11-08-9

(4)

W/O:		WORK ORDER CHANGES						
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Picklist Print

Wednesday, April 27, 2011 11:28:06 AM

Page 1

Work Order ID: 69052



Parent Item: D3955-23



Parent Item Name: Template

Start Date: 4/27/2011

Required Date: 5/3/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.040

Purchased

No

sf

14.0000

1.668211



B11-5-5

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

14

113004

14

113004

4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

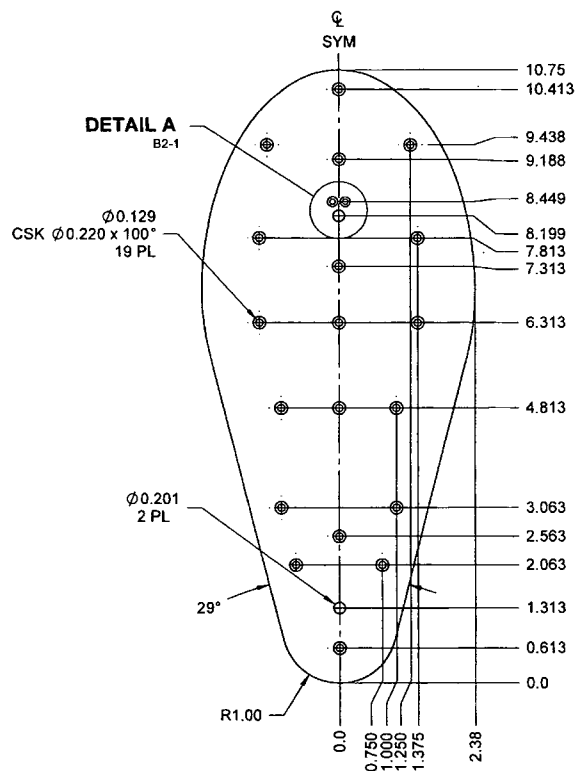
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



0.063
REF

INSTALL
MS21086L3 NUT PLATE
MS20427M3-3 RIVET, 2 PL

CSK SIDE

D3955-1
DOUBLER

0.219

0.110

Ø 0.201
REF

DE
SC





D3955-1 DOUBLER

D3955-1 NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

D3955-041 DOUBLER ASSEMBLY

RELEASE
09/07/22 NMP

A	NEW ISSUE		RF	09.07.21
REV.		DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3955 TITLE SKIDTUBE TUNING KIT		
DRAWN	RF			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.07.21	<p align="center">COPYRIGHT © 2009 BY DART AEROSPACE LTD</p> <p align="center">THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</p>		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAFTING NO.

D3955

REV A

SHEET 1 OF 5

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100

SKIDTUBE TUNING KIT

NOTES

ACE LTD

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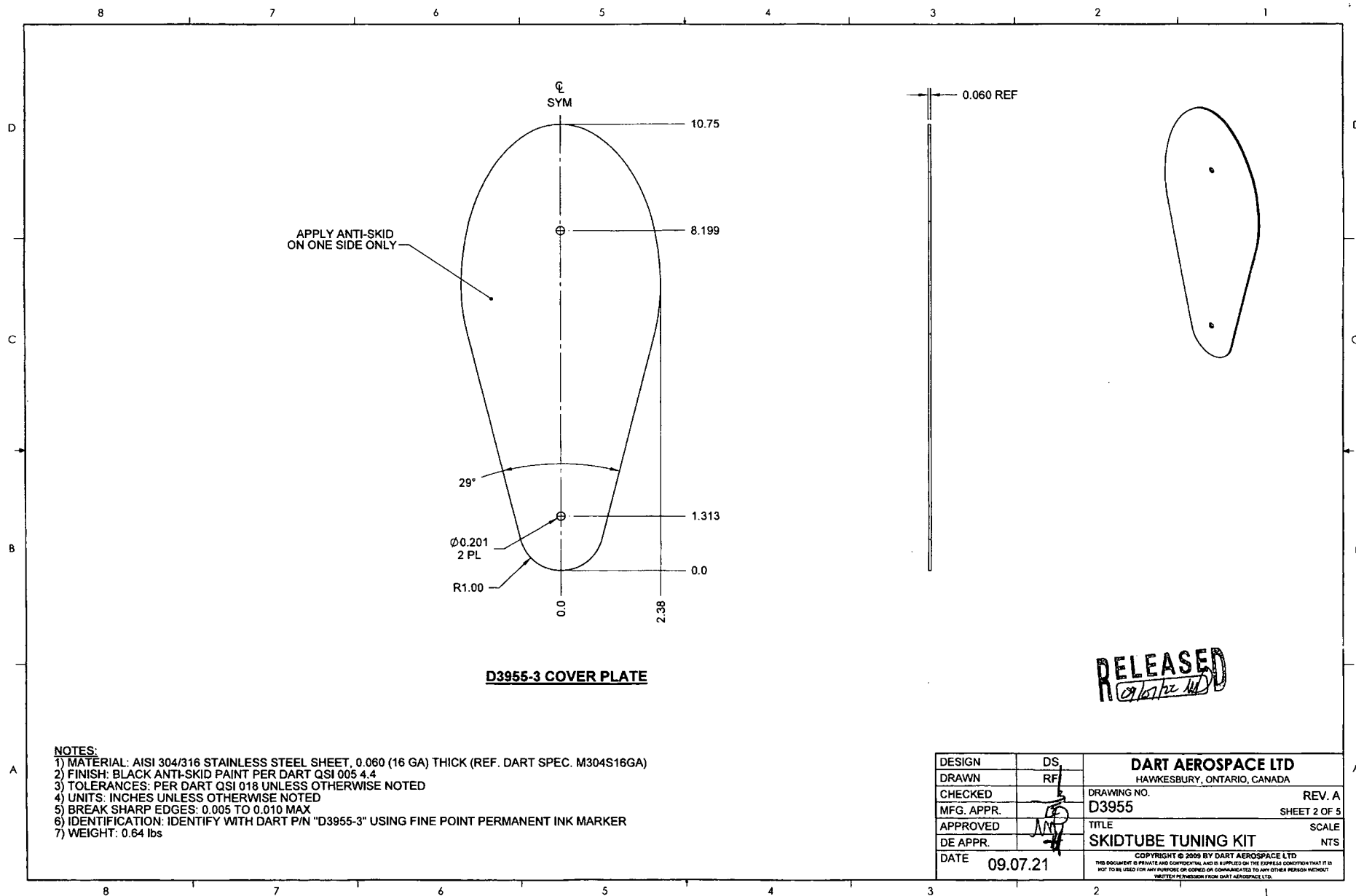
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
09/10/22 M

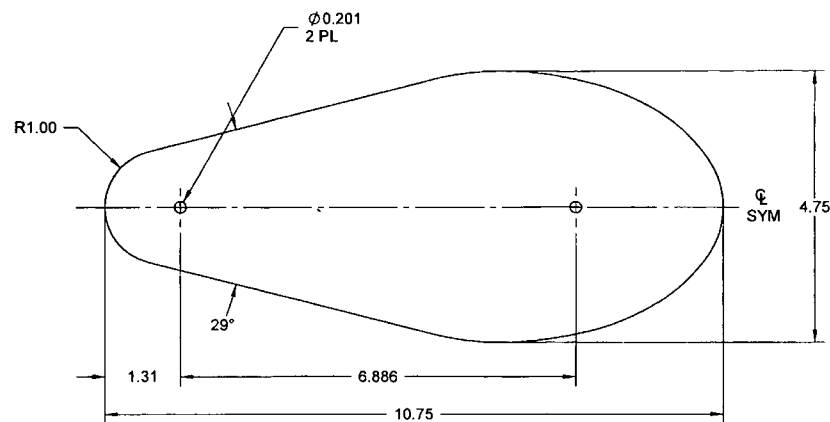
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D3955-X PLATE

General Table			
P/N	T (in)	T (GA)	WEIGHT (lbs)
D3955-5	0.060	16	0.64
D3955-7	0.120	11	1.28

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, T (GA) THICK (REF. DART SPEC. M304ST'GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE TABLE

RELEASED
6/10/12 MDD

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE TUNING KIT	NTS
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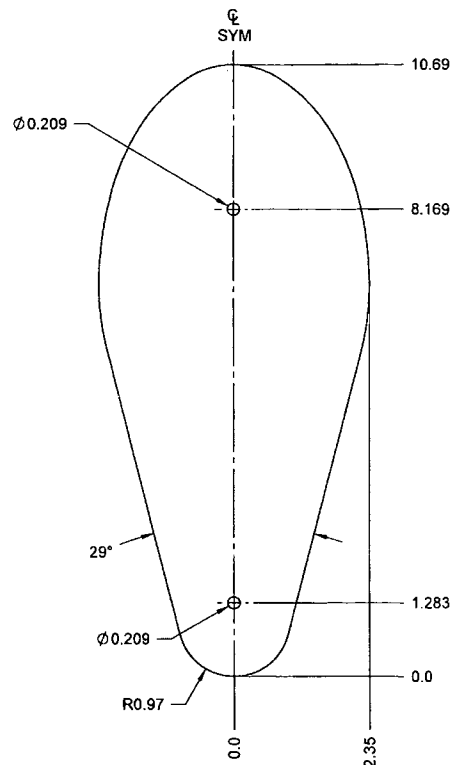
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3955-21 GASKET

D3955-21 NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER (REF. DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3955-21" USING YELLOW PAINT MARKER
- 7) WEIGHT: 0.08 lbs

RELEASED
07/07/22 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3955	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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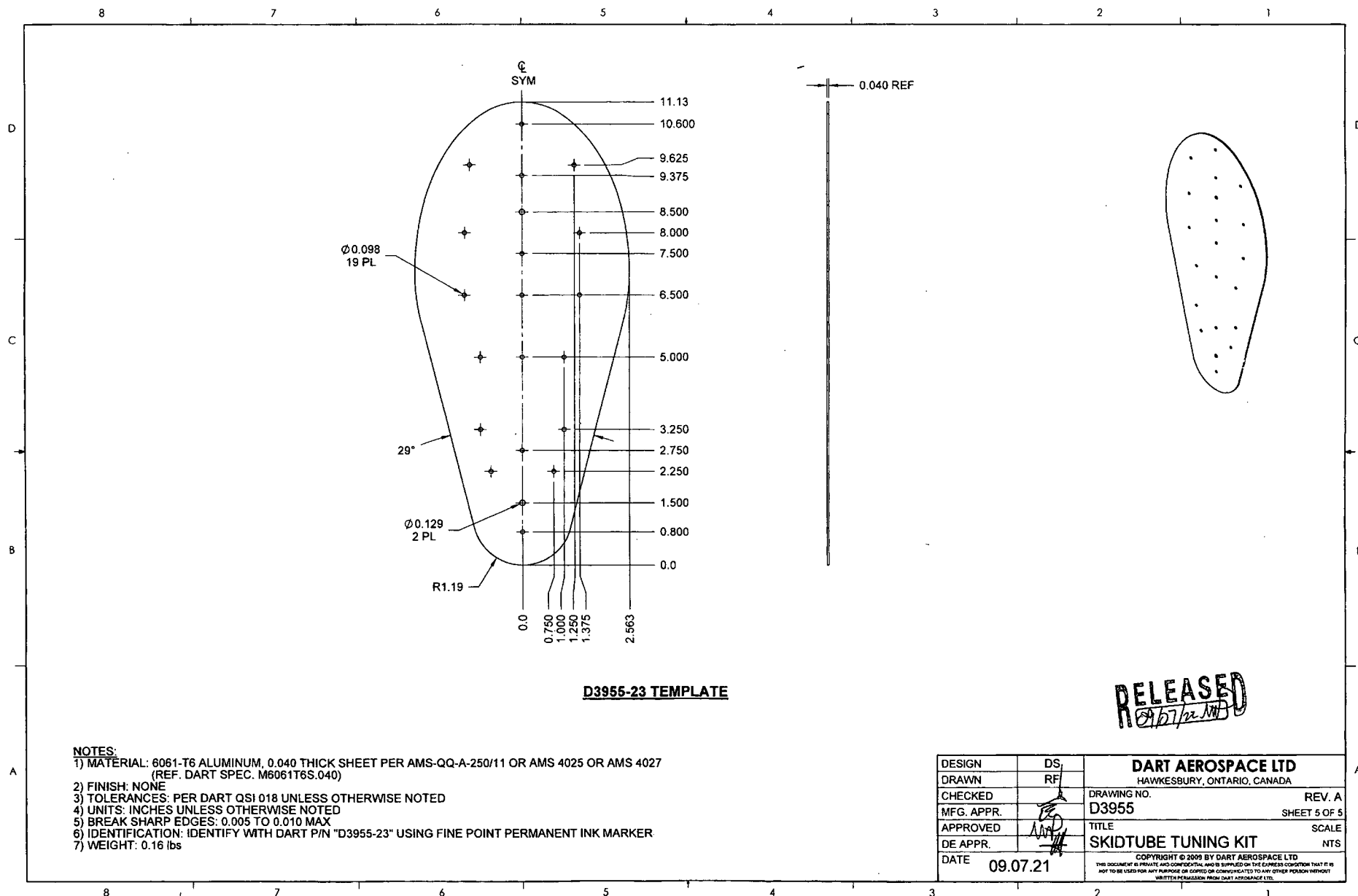
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DART AEROSPACE LTD		Work Order: 19052
Description: Template		Part Number: D3955-23
Inspection Dwg: D3955	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.100	✓		V 1B02	
Ø0.129	+0.005/-0.001	.130	✓		V	
0.750	+/-0.010	.755	✓		V	
1.000	+/-0.010	.999	✓		V	
1.250	+/-0.010	1.252	✓		V	
1.375	+/-0.010	1.376	✓		V	
2.563	+/-0.010	2.563	✓		V	
0.800	+/-0.010	.798	✓		V	
1.500	+/-0.010	1.499	✓		V	
2.250	+/-0.010	2.249	✓		V	
2.750	+/-0.010	2.751	✓		V	
3.250	+/-0.010	3.252	✓		V	
5.000	+/-0.010	5.004	✓		V	
6.500	+/-0.010	6.496	✓		V	
7.500	+/-0.010	7.499	✓		V	
8.000	+/-0.010	8.003	✓		V	
8.500	+/-0.010	8.494	✓		PROW302	
9.375	+/-0.010	9.373	✓		P	
9.625	+/-0.010	9.624	✓		P	
10.600	+/-0.010	10.598	✓		P	
11.13	+/-0.030	11.125	✓		P	
0.040	+/-0.010	.038	✓		V	

Measured by: B	Audited by: J	Prototype Approval:	N/A
Date: 11-5-5	Date: 11/6/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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